

Work Order ID 63597

Thursday, November 04, 2010 1:05:10 PM

Page 1

Item ID: D2154

Accept

Setup Start

Revision ID:

Stop

Item Name: Stud Bracket

Start Date: 11/4/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 11/25/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: MDate: 12-11-04 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2154

Rev C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2154 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

364 . 063

B10-11-9

(16)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B10-11-9

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Sioluko

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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[illegible]

Page 2



Stop

Abstract



Customer:

██████████
██████████

Run Start

[illegible]

Stop

**Insp.
Stamp**

0.00

[REDACTED]

m 11595).

- 0.00

Powdercoat

Memo

Powder Coating

START TIME:

245

☐ OVEN TEMPERATURE:

4000 FINISH TIME:

3.15

0.00

[illegible]

$\Rightarrow M_1 \text{ ist } 10/12/10/8$

QC

Memo

0.00

Quality Control

0.00

[illegible]

10/12/19

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
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Work Order ID 63597

Thursday, November 04, 2010 1:05:10 PM

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Item ID: D2154 Accept  Setup Start 
Revision ID:
Item Name: Stud Bracket Stop 
Start Date: 11/4/2010 Start Qty: 10.00  Cust Item ID:
Required Date: 11/25/2010 Req'd Qty: 10.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							 10/12/07  PS-10-12-7 

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Picklist Print

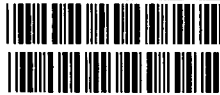
Thursday, November 04, 2010 1:05:14 PM

Page 1

Work Order ID: 63597

Parent Item: D2154

Parent Item Name: Stud Bracket





Start Date: 11/4/2010

Required Date: 11/25/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C 03.08.08 Reformat; Remove Tumble KJ/RF
IPP Rev:D NowOn Waterjet 07-04-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	178.9000	0.0333	0.350526	16		
304/316 Sheet .063											1810-11-9		

Location

Loc Qty

Loc Code

MAT

178.9

111323

0

115688

18.9

115953

160

115688

(16)

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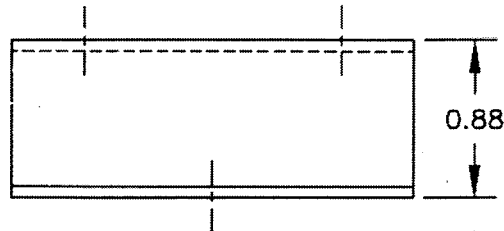
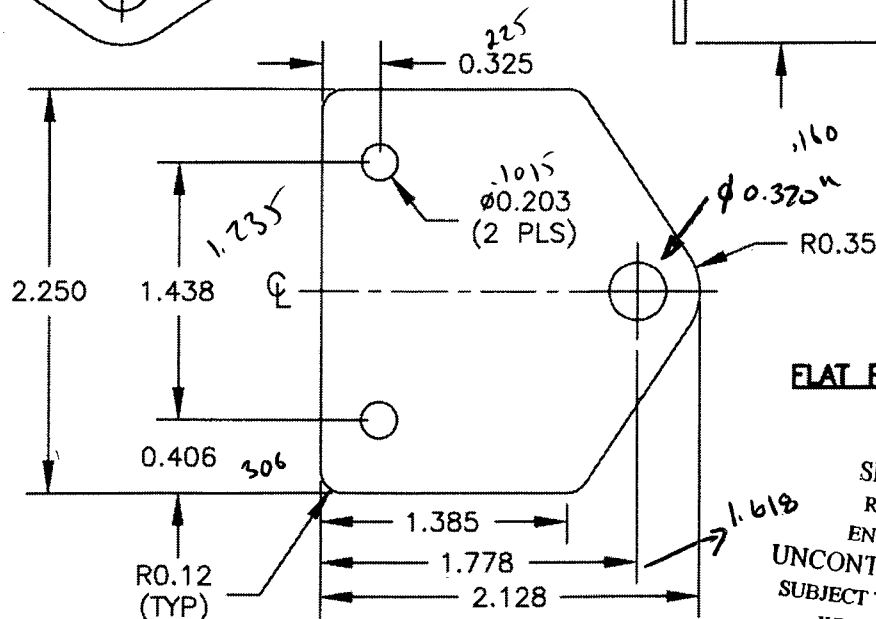
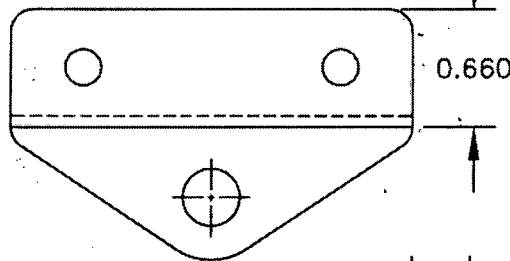
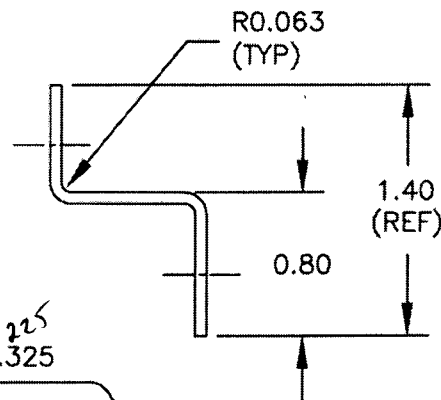
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DART

DESIGN GH	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2154	REV. C SHEET 1 OF 1
DATE 04.10.12	TITLE BRACKET, STUD		SCALE 1:1
A	92.07.28	NEW ISSUE	
B	98.09.15	UPDATE FLAT PATTERN; ADD P/COAT	
C	04.10.12	0.88 WAS 0.875; 2.128 WAS 2.068	

RELEASED

04.10.15 *[Signature]***BEND DETAIL****FLAT PATTERN****D2154 NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH 0.063 THICK (M304S16GA)
- 2) FINISH: POWDER COAT WHITE (REF: 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH PART NUMBER AND BATCH NUMBER USING A FINE POINT PERMANENT INK MARKER.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *63527*
BS10-11-04

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